

5/16 W.058

Work Order ID 151967

151967

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Friday, October 14, 2016 1:56:15 PM

Item ID: D3681-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 10/27/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/2/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

9-89

Date: OCT 17 2016

Cooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3681

Rev A

100

100

Hardinge

Hardinge CNC LATHE SMALL

0.05

Memo

0.13

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: AA

DWG REV: A

2-DEBURR AS REQUIRED

DAS

45

9-89

16-10-25

110

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.07

Quality Control

DAS

45

9-89

16-10-25

120

120

QC

QC8- Inspect parts - second check

0.00

Memo

0.13

Quality Control

DAS

33

9-89

16/10/25

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Item ID: D3681-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 10/27/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/2/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125									
Skidtubes	Memo	0.13							
Skidtubes	1- clean crossbolt spacer with ultra brighth aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location LG001	0.00							
130									
Packaging	Memo	0.07							
Packaging	***STOCK IN SKIDTUBE CELL*** LOCATION : LG001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.67							
Quality Control									

DAS
21
9-89

OCT 27 2016

DAS
21
9-89

OCT 26 2016

Picklist Print

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Work Order ID: 151967

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Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 10/27/2016

Required Date: 11/2/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD
seq 125 DD 10.05.03 verified by:EC

IPP Rev:C add

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No			100	f	96.0000	0.34	14.31579			

M6061T6T0 3125W 058

ALUM TUBE .3125 x .058w

Location

Loc Qty

Loc Code

MAT013

96

m135250

24

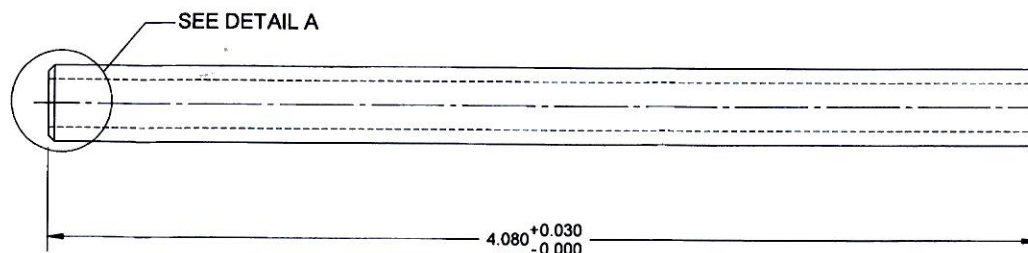
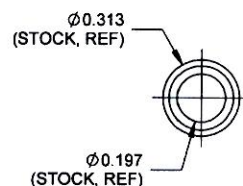
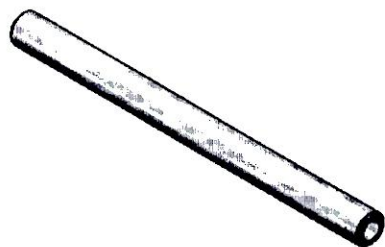
m135373

48

m135565

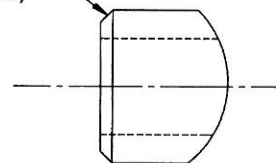
24

DAS
45 16-10-25
9-89
24.0 ^{PS}
24.0 ^{PS}
48.0 ^{PS}



D3681-1 SPACER

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151967 MJS

16-10-17

RELEASED
07-11-09

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC	07.11.08
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	SC				
CHECKED	MD	DRAWING NO. D3681		REV. A	
MFG. APPR.	MD				SHEET 1 OF 1
APPROVED	MD	TITLE SPACER			SCALE 2:1
DE APPR.	MD				
DATE	07.11.08				

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